

**Work Order ID 59101**

Wednesday, May 26, 2010 1:33:41 PM



Page 1

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Item Name: Basket Base Assembly

Stop



Start Date: 5/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-5-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3172	Rev C								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut Qty 4 D3166-1 as per Dwg D3172 □ 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 □ 3-Drill holes in D3172-3 as per Dwg D3172 □ 4-Debur & Remove all markings from material □ 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Debur as r				SAD 10-06-07				
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC6- Inspect dimensions to drawing	0.00							
	QC								
Quality Control	Memo	0.00							

10.06.10

Cpl 10.06.07

Sobolov

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Start Date: 5/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

PRESSURE WASH  
Memo

0.00

=> MW 10/06/09

① BR 10-6-9

①

1ST COAT:  
START TIME: 1:15pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 1:45pm

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:  
START TIME: 2:00pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 2:30pm

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

① BR 10-6-10

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Item ID: D3172-041 Accept  Setup Start   
Revision ID:  
Item Name: Basket Base Assembly Stop   
Start Date: 5/27/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 6/11/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: <u>G-A</u> Memo w/o B59099	0.00 0.00							<u>ES 10/06/10</u> @
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/06/10</u> JF MF 10-6-10

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Wednesday, May 26, 2010 1:33:45 PM

Page 1

\_\_\_\_\_

**Required Date: 6/11/2010**

**Required Qty: 1.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117  Clevis		Manufactured	No			100	Each	39.0000	2	2		10.06.08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		39							
					52498	9							
					55729	30							
D2232-3  Basket Hinge		Manufactured	No			100	Each	10.0000	2	2		10.06.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
					57502	4							
					57793	6							
D2327-3  Spacer Bushing		Manufactured	No			100	Each	19.0000	2	2		10.06.04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		19							
					58406	19							
D2581  Mounting Bracket		Manufactured	No			100	Each	34.0000	2	2		10.06.07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		34							
					46086	2							
					51745	2							
					57185	1							
					58301	9							
					58687	20							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 26, 2010 1:33:45 PM

Page 2

Work Order ID: 59101

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly


Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF  
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-1		Manufactured	No			100	Each	19.0000	4	4			
													
Basket Hoop													

Location Loc Qty Loc Code

WA 19  
57592 7  
57999 12

D3174-1 Manufactured No

100 Each 12.0000 8



Mounting Lug

Location Loc Qty Loc Code

WA 12  
41632 12

M304EX0.75-16F Purchased No

100 sf 586.5561 48



Expanded Metal Flat SS

Location Loc Qty Loc Code

MAT 586.5561368  
111956 28  
112949 12  
113497 6.34  
113555 22.2888368  
114399 108.1523  
114594 89.775  
114744 320

10.06.03

4

10.06.03

3

SAO 10-06-07

48.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	1,200.557	51	53.68421			
													
304 SQ Tube .75x.75x.065W													

Location

Loc Qty

Loc Code

MAT

200.5571

112398

0

114482

200.5571

WA

1000

114520

1000

SAD 10-06-04

53.6842

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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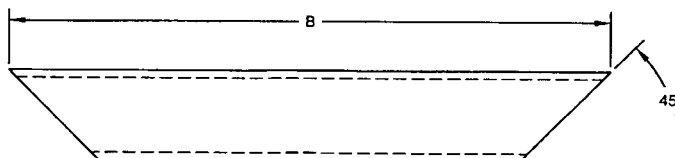
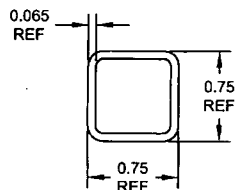
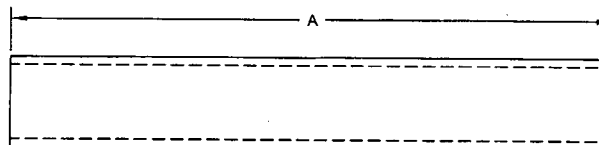
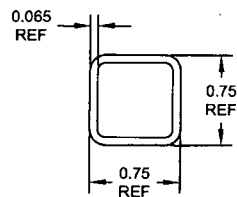
**NOTE:** Date & initial all entries

# PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59101

*10-5-26*



RELEASED  
*08-07-21/12*



## NOTES:

- MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3172	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

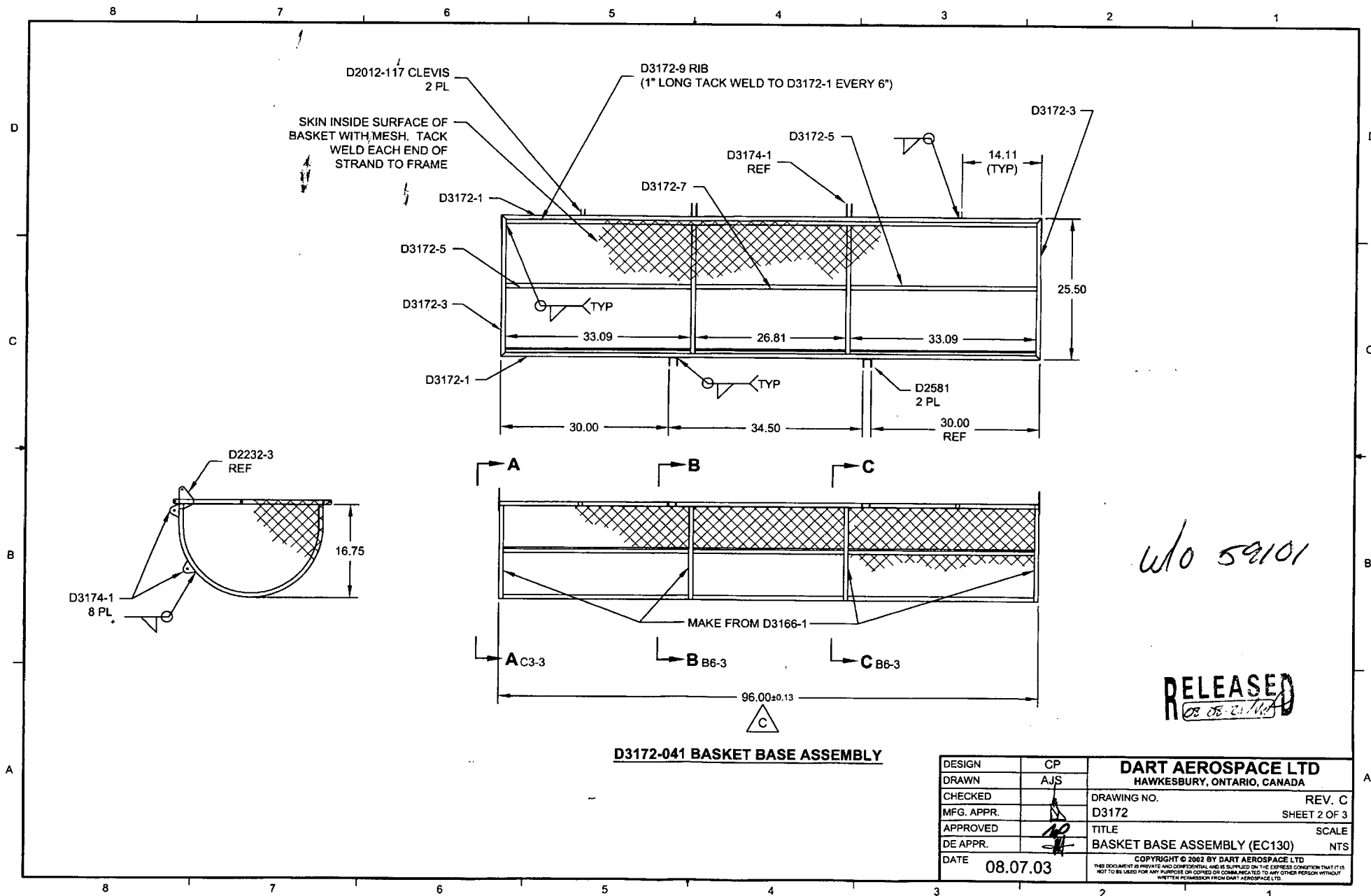
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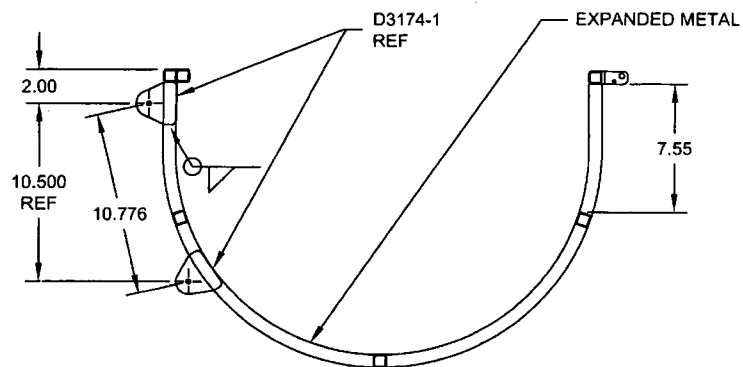
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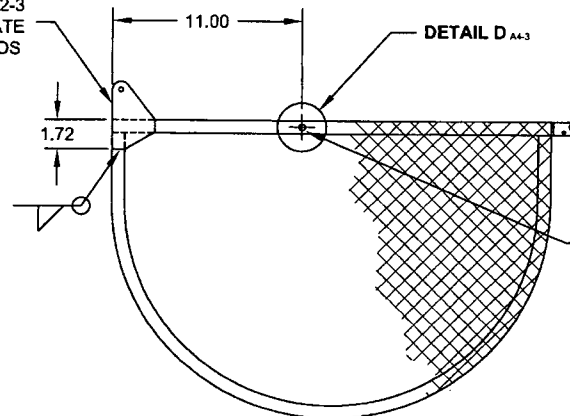
8 7 6 5 4 3 2 1

D

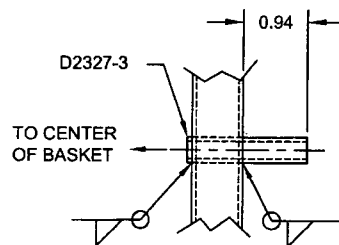


**SECTION B-B<sub>B5-2</sub>  
AND SECTION C-C<sub>B3-2</sub>**  
RIB DETAIL  
SCALE 2X

D2232-3  
HINGE PLATE  
BOTH ENDS



**SECTION A-A<sub>B5-2</sub>**  
SPACER DETAIL  
SCALE 2X



**DETAIL D<sub>D3-3</sub>**  
SCALE 4X

*w/o 39101*

**RELEASED**  
08-08-21 1140

B

A

8 7 6 5 4 3 2 1

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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